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D3712-042
Job Sheet 174138



Part No: D3712-042

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 4/24/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG D3726 REV A, D3727 REV A, D3739 , D3740 REV A, D3712 REV B, D3735 REV B, D3746 REV B IPP
Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B chg to revB ecn 1145 08-03-19 DD verified by:JLM
IPP Rev:C 10.10.21 added pressure wash DD verf:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/23/18	4/23/18	0.00	0.00	Start Up Large Fab-5		DC 2018-03-16
100	Large Fab	1 pcs	4/24/18	4/24/18	0.00	16.67	Large Fab 1	DM 24h	DC 2018-03-16
110	Large Fab	1 pcs	4/24/18	4/24/18	0.00	16.67	Large Fab 1	24h	DC 2018-03-25
120	QC	1 pcs	4/24/18	4/24/18	0.00	0.00	QC5		PD 18-3-29
130	QC	1 pcs	4/24/18	4/24/18	0.00	0.00	QC9		PD 18-3-29
135	HandFinish	1 pcs	4/24/18	4/24/18	0.00	0.31	HandFinish2		BD 18-04-02
140	Powdercoat	1 pcs	4/24/18	4/24/18	0.00	0.78	Powdercoat2		BD 18-4-3
150	QC	1 pcs	4/24/18	4/24/18	0.00	0.00	QC3		HL 18-04-07
160	Packaging	1 pcs	4/24/18	4/24/18	0.00	0.00	Packaging1-4		HL 18-04-09
170	Small Fab	1 pcs	4/24/18	4/24/18	0.00	0.87	Small Fab-4		HL 18-4-9
180	QC	1 pcs	4/24/18	4/24/18	0.00	0.00	QC5		HL 18-4-9
190	Packaging	1 pcs	4/24/18	4/24/18	0.00	0.00	Packaging3-1		HL 18-4-9
200	QC21-SA	1 Ea	4/24/18	4/24/18	0.00	0.00	QC21		21 APR 11 9:28 AM

P.T.O.

Part Op 100 - 1- Take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7 using DT8996 2-
Descriptions: Take D3746-3, D3746-5, D3746-7 and drill holes as per dwg D3746 using drill jig DT8995 and DT8996 3- Drill holes in
both D3727-1 as per dwg D3727 4- Drill holes in D3735-3 as per dwg D3735 using DT9000 jig 5- Deburr
110 - 1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745
140 - First coat: START TIME: 8:45 OVEN TEMPERATURE: 375° FINISH TIME: 9:00 ***if
necessary*** Second coat: START TIME: OVEN TEMPERATURE: FINISH TIME:
170 - Assemble as per dwg D3712

4
4008

Job BOM 002320				
Part / Item	Component Name	Quantity	Operation	Container
D2327-3	Spacer Bushing	2 Ea (2 ea)	90-Start up Operation	5038301
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5042562
D3166-1	Basket Hoop	5 Ea (5 ea)	90-Start up Operation	5017277
D3725-1	Hoop	2 Ea (2 ea)	90-Start up Operation	5017431
D3748-1	Hinge Half	3 Ea (3 ea)	90-Start up Operation	103063
D3757-1	Blanking Plate	2 Ea (2 ea) Small Fab	90-Start up Operation	5045115
D3759-1	Bushing	21 Ea (21 ea)	90-Start up Operation	5041099
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	42.6590 ft (42.659 ea)	90-Start up Operation	508917
M304EX0.75-16F	Expanded Metal Flat SS	38 sf (38 ea) Start up	110-Large Fab	5049717
AN3-11A	Bolt	6 Ea (6 ea)	170-Small Fab	5027721
D2931	Bumper	2 Ea (2 ea)	170-Small Fab	F86435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Small Fab	5042091
MS21042L3	Nut	6 Ea (6 ea)	170-Small Fab	5038764
NAS1149D0363J	Washer	12 Ea (12 ea)	170-Small Fab	5015269
NAS1149DN832J	Washer	2 Ea (2 ea)	170-Small Fab	FMI137567-17

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2327-3	2	6	0
	D2581	2	64	0
	D3166-1	5	14	0
	D3725-1	2	4	0
	D3748-1	3	7	0
	D3757-1	2	10	0
	D3759-1	21	136	0
	M304TS0.750W.065	43	658	0
	M304EX0.75-16F	38	958	0
	AN3-11A	6	348	0
110-Large Fab	D2931	2	1,110	0
170-Small Fab	MS20600-AD4W3	2	215	0
	MS21042L3	6	2,895	0
	NAS1149D0363J	12	3,156	0
	NAS1149DN832J	2	2,406	0

Part Specifications

Specifications could not be found.



DQA: _____ Date: mo 19 Jan 2019

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: <u>124138</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS				Engineering Quality Other	
Part No. <u>D3746-092</u>		☐ Rework ☐ Scrap ☒ Use-as-is		☐ Skid-tube Machining ☐ Thermofforming Large Fab		☐ Cross tube Small Fab ☐ Finishing Composite		☐ Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier	
NCR No. <u>19-7195</u>		Suspected Unapproved		QTY Effective: ☒					
Date: <u>18-3-16</u>		Step #: <u>100</u>		Disposition <u>4</u>		MRB (QSI042) Approval			
Description Work Order Deviation				Disposition		Completed By			
Holes in rib D3746-3 (1v) D3746-5 (2v) and D3746-7 (1v) was drill in wrong location				Scrap destroy rib: -D3746-3 (1v) D3746-5 (2v) D3746-7 (1v)		PD 18-3-26 2018-03-26		Lead hand / Supervisor Approval Verification	
P.C. operator not verifying work before drilling.				Replace by taking D3166.1 (4v) and trim to make new D3746-3, -5, -7 per drawing. (3166-1 5050110 4v) Make sure to verify hole location before drilling.		PD 18-3-26		QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment		☐ No Re-verification		Pressure/Forced		☐ Temperature/Cure		☒ Positioned Wrong	
Design		☒ Operator		Bending		Set-up		☐ Power Loss/Surge	
Doc/Data		☐ Offset/Setup		Centre Not Concentric		BOM/Route		☐ Folio/Program	
Equip/Tooling		☐ Supplier		Cracks		Broken/Damage/Defect		☐ Grain	
Handling/Pre		☐ Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		☐ Weld	
Material		☐ Use for Testing		Cuffs		Contamination		☐ Wrong Stock Pulled	
Internal Transport		☐ Poor Information		Crushing		Countersink		☐ Out of Sequence	
Tribal Knowledge		☐ Rushing		Heat Treat		Cut Too Short		☐ Off-set	
LOA		☐ Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		☐ Mislabeled	
Substation		☐ Process Improvement		Marks/Chatter		Drill Holes		☐ Fit/Function	
Past Expiry Date		☐ Manufacturing Process		OTHER: _____				☐ Misaligned/off center	
Misidentified		☐ Past Due						☐ Turning Sequence	